

Work Order ID 62279

September 24, 2010 1:56:49 PM



Page 1

Item ID: D206-642-541

Accept



Setup Start



Revision ID:

Item Name: Replacement Skidtube

Stop



Start Date: 9/24/10 Start Qty: 1.00



Cust Item ID:

Required Date: 10/08/10 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: CL Date: 10/9/24 Tooling:

Date:

Run Start



QC: Date: SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3274

D

IIN-D206-642

Rev M

100

0.00



DOCUMENT CONTROL

DC

0.00

Document Control

Memo

Photocopy bluefile & type labels per PPP D206-642-541

CHG003

N/A CL 10/12/13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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110

0.00



Skidtubes

0.00

Skidtubes

Memo

VERIFY AND INSPECT THE MATERIAL PRIOR TO USE

1- Bend FWD end of tube using bend prog D3274 FWD and foil 10 as per dwg D3274, cut fwd end of tube with saw table setup D3274.

2- remove fwd indexing ridge as per dwg D3274. Prepare for welding

3- weld fwd cap as per dwg D3274 and OSI004

AR Aluminum Rod Batch: M112507

4- grind fwd cap weld on top surface only

5- Cut AFT end of tube at 170.9" as per dwg D3274 and deburr end.

6-Drill Aft cap pilot hole using DT8025

7 -Cleco DT8025 in position and install pilot hole drill Jig DT8742A,B,C,D.
Drill 3/16" pilot holes as per Dwg D32748 -Remove inner indexing ridge on aft end of skidtube as per Dwg D3274 scribe
batch #

9 -Open aft end cap holes to Ø0.208" as per Dwg D3274. Deburr aft end.

DP 10-10-4

BE 10-10-4

BE 10-10-5

BE 10-10-5

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Stop

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

120

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

6 - BE 10/10/25

130

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

S 10/10/05

140

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

S 10/10/05

(70)

W/O:		WORK ORDER CHANGES					
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QC: Date: SPC (Y/N): Date:

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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150



Skidtubes

Skidtubes

Skidtubes

Memo

1-Open Ø0.313" and 0.375" crossbolt spacer holes using DT8743 as per Dwg D3274

2-Deburr crossbolt spacer holes as per Dwg D3274 and blow out chips from inside the tube

3-Bond web in place as per Dwg D3274 & QSI 015.

A/R ☐ Sikaflex-291 ☐ MISSING ☐

Sikaflex expire date: ☐ 11/01/30 ☐

Start: ☐ 1:00 ☐ Time: ☐ 10/11/04 ☐

Finish: ☐ 10/11/04 ☐ Time: ☐ 10:30am
(Adhere for 12 hours)

0.00

0.00

0.00

160



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

8/10/10

DP 10-10-6

XI

BB 10/11/04

W/O:		WORK ORDER CHANGES					
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Run Start

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Stop

QC: Date: SPC (Y/N): Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

170

0.00



Skidtubes

Skidtubes

Memo

0.00

1-Bend AFT end of tube using bend prog. D3274 AFT as per dwg D3274. Install drop pins in crossbolt spacer holes to maintain web position.

2- DRILL PILOT HOLES FOR WEARPLATES USING D3274-1T2
OPEN HOLES TO .297" . Deburr3-DRILL TOE PIN HOLE .640" DIA AS PER DWG USING DT8935 FWD
END OF TUBE
DEBURR INSIDE OF HOLE AS NECESSARY (DO NOT ENLARGE HOLES)
REMOVE ANY FOREIGN OBJECTS INSIDE OF TUBES

4- Countersink crossbolt spacer holes as per Dwg D3274

5- prepare for welding

180

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

8/10/10/08

L° = 4.6°
h = 3.04

(K)

DP 10-11-8

DP 10-11-8

W/O:		.WORK ORDER CHANGES					
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Run Start

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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190

0.00



Skidtubes

Skidtubes

Memo

0.00

1-Insert D2649 & D3275-1 crossbolt spacers. Weld as per QSI 004 and Dwg D3274. Remember to back drill each hole before welding the other side. Use aluminum rod
A/R ☐ Aluminum Rod ☒ *MIL385*

3-Grind cross bolt welds flush as per Dwg D3274.

4-Counterbore 5/16" x 0.750" deep as per Dwg D3274 and deburr.

BE 10/11/10
BE 10/11/10
BE 10/11/10

200

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

Solaki

(Signature)

W/O:		WORK ORDER CHANGES					
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Customer:

Reference:

Run Start

Approvals: Process Plan: Date: Tooling: Date:

Stop

QC: Date: SPC (Y/N): Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

210

QC10- Inspect visual per QSI004- ground welds

0.00



QC

Memo

0.00

Quality Control

220

Pressure Wash per QSI005 4.3

0.00



HandFinish

Memo

0.00

Hand Finishing

Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch

230

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

0.00

Powder Coating

START TIME: 11:35
OVEN TEMPERATURE: 320°
FINISH TIME: 12:05

1 BL 10-11-15

W/O:		WORK ORDER CHANGES					
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Required Date:	10/08/10	Req'd Qty:	1.00		Customer:	
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
240  QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00		27 M 10/11/16		1	d		
250  HandFinish Hand Finishing	HandFinishing Memo 1-Install Nut Plate as per Dwg D3274. Apply LPS-3 to Nut Plate and rivets. A/R <input type="checkbox"/> Sikaflex-291 <input type="checkbox"/> M109956 2-Install inserts as per Dwg D3274. Use a drop of Sikaflex inside insert holes a A/R <input type="checkbox"/> Sikaflex-291 <input type="checkbox"/> M115114 Sikaflex expire date: <input type="checkbox"/> 11/01	0.00 0.00		27 M 10/11/16		1	Ø		
260  QC Quality Control	QC5- Inspect part completeness to step on W/O Memo Inspect Nut Plate & Inserts	0.00 0.00		8 10/11/16					

W/O:		WORK ORDER CHANGES					
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Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

270



HandFinish

Hand Finishing

HAND FINISHING RESOURCE #1

0.00

=> 90

10/11/16

1

0

Memo

1-Install wearpads & gaskets as per Dwg D3274.

2-Install ring as per Dwg D3274

A/R ☐ Sikaflex-291 ☐ 11/5/14

Sikaflex expire date: ☐ 11/01

3-Inspect for foreign objects as per QSI 024

4-Spray inside of tube on both sides of web with LPS-3

A/R LPS-3 Batch: N/A

5-Install Aft Cap and seal with Sikaflex. Clean excess adhesive.

A/R ☐ Sikaflex-291 ☐ 11/5/14

Sikaflex expire date: ☐ 11/01

280



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Schultz

20

Memo

0.00

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
290 Packaging	Identify as per dwg & Stock Location: _____ Memo <i>PRR 63382</i>	0.00 0.00							<i>640/12/10</i>
300 QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							<i>CK 10/12/13</i> <i>PS 10-12-10</i> <i>U</i>

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Picklist Print

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Required Date: 10/08/10

Start Qty: 1.00


Required Qty: 1.00

Comments: IPP Rev:B 05.09.23 Revised per D206-642 Rev. J KJ/JLM
 IPP Rev:C 07-02-23 Added SS Wearplates & Gaskets JLM
 IPP Rev:D 07-12-06 replace NAS1515H3L to D3672-1 DD
 IPP Rev:E 08-04-17 as per PAR 08-015 DD verified by:EC
 IPP Rev:F 08-06-02 add comment DD verified by:EC
 IPP Rev:G 08-10-09 revise details DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2600-1-190 		Manufactured	No			110	Each	74.0000	1	1			
Extrusion Round 3" 206													


Location	Loc Qty	Loc Code
LG	74	
47575	26	
59874	48	

DP 10-10-4

D3285-1 		Manufactured	No			110	Each	141.0000	1	1			
Cap													

Location	Loc Qty	Loc Code
LG	141	
52511	74	
52647	67	

BE 10-10-4

D3282-041 		Manufactured	No			150	Each	3.0000	1	1			
Float Web (206L/407)													

Location	Loc Qty	Loc Code
LG	3	
59886	3	
60931		

X/ BB 10/11/04

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Required Date: 10/08/10

Start Qty: 1.00

Required Qty: 1.00

D2649 Manufactured No 190 Each 107.0000 1 1



Cross Bolt Spacer

Location	Loc Qty	Loc Code
LG	107	
58545	2	
60652	4	
61496	101	



B63359 (12) BE 10/11/09

D3275-1 Manufactured No 190 Each 184.0000 12 12



Crossbolt Spacer

Location	Loc Qty	Loc Code
LG	184	
53453	8	
60653	3	
61646	173	



12 BE 10/11/09

CR3212-4-03 Purchased No 250 Each 1,898.000 2 2



Cherry Rivet

Location	Loc Qty	Loc Code
ST311	1898	
111359	5	
112314	2	
114436	448	
114450	77	
114859	1366	



12 BE 10/11/09

D3415-041 Manufactured No 250 Each 55.0000 1 1



Nut Plate

Location	Loc Qty	Loc Code
ST056	55	
33842	55	



12 BE 10/11/09

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Shop Packet Print

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Start Date: 9/24/10

Required Date: 10/08/10

Start Qty: 1.00

Required Qty: 1.00

CCR264SS3-3

Purchased

No

250

Each

456.0000

2

2



Cherry Rivet



10/11/10

Location

Loc Qty

Loc Code

ST311

456

112314

4

113539

44

113973

408

x2

ALS4-1032-130

Purchased

No

250

Each

2,044.000

78

78



Insert



10/11/10

Location

Loc Qty

Loc Code

PKG11

1995

M115911

x78

114723

1995

ST282

10

110511

10

ST381

39

114654

39

D3536-15

Manufactured

No

270

Each

17.0000

1

1



Gasket



10/11/10

Location

Loc Qty

Loc Code

FP

16

56055

4

60875

12

FP11

1

59238

1

B62459

x1

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Start Qty: 1.00

Required Qty: 1.00

D3536-23 Manufactured No

270 Each

15.0000

1

1



Gasket



10/11/16

Location

Loc Qty

Loc Code

FP011

15

B63238

Y1

60234

4

61237

11

D3536-35 Manufactured No

270 Each

16.0000

1

1



Gasket



10/11/16

Location

Loc Qty

Loc Code

FP012

16

B62462

Y1

58683

1

60235

3

61692

12

D3536-39 Manufactured No

270 Each

15.0000

1

1



Gasket



10/11/16

Location

Loc Qty

Loc Code

FP12

15

58215

1

58571

14

D3535-15 Manufactured No

270 Each

13.0000

1

1



Wearshoe



10/11/16

Location

Loc Qty

Loc Code

FP18

13

B62707

X1

61241

13

September 24, 2010 1:56:49 PM

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Page 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 5

Work Order ID: 62279

Parent Item: D206-642-541

Parent Item Name: Replacement Skidtube

Start Date: 9/24/10

Required Date: 10/08/10

Start Qty: 1.00

Required Qty: 1.00

D3535-35 Manufactured No 270 Each 13.0000 1 1
Wearshoe

Location

Loc Qty

Loc Code

FP018

13

1362461

60865

13

D3535-39 Manufactured No 270 Each 19.0000 1 1
Wearshoe

Location

Loc Qty

Loc Code

FP18

19

58214

2

60233

17

D3535-23 Manufactured No 270 Each 25.0000 1 1
Wearshoe

Location

Loc Qty

Loc Code

FP

12

61830

12

FP021

23

60231

11

FP21

2

60864

2

D3537-3 Manufactured No 270 Each 18.0000 1 1
Wearpad

Location

Loc Qty

Loc Code

FP17

17

60866

17

FP19

1

59711

1

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Page 5

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

September 24, 2010 1:56:49 PM

Work Order ID: 62279

Parent Item: D206-642-541

Parent Item Name: Replacement Skidtube

Start Date: 9/24/10

Required Date: 10/08/10

Start Qty: 1.00

Required Qty: 1.00

D3537-1 Manufactured No

270 Each 87.0000 9 9



Wearpad

Location

Loc Qty

Loc Code

FP	1	363313	x9
55465	1		
FP17	86		
57713	3		
60491	3		
61640	80		

AN960C10L NAS1149C0332 Purchased No

270 Each 29.0000 80 80



washer

Location

Loc Qty

Loc Code

ST245	29		
107534	29		

AN960C416 NAS1149C0463 Purchased No

270 Each 103.0000 1 1



washer

Location

Loc Qty

Loc Code

ST346	103		
100993	103		

D3672-1 Manufactured No

270 Each 869.0000 2 2



Phenolic Washer

Location

Loc Qty

Loc Code

ST077	869		
42329	150		
52505	719		x2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 7

Work Order ID: 62279

Parent Item: D206-642-541

Parent Item Name: Replacement Skidtube

Start Date: 9/24/10

Required Date: 10/08/10

Start Qty: 1.00

Required Qty: 1.00

AN3C4A

Purchased

No

270

Each

2,108.000

80

80



BOLT



10/1/10

Location

Loc Qty

Loc Code

ST245

38

109061

11

110139

27

ST303

42

115438

42

ST350

2028

114108

14

114416

12

114523

2

115300

1000

115589

1000

x80

AN4C5A

Purchased

No

270

Each

495.0000

1

1



BOLT



10/1/10

Location

Loc Qty

Loc Code

ST346

495

110552

7

112243

488

x1

D2646

Manufactured

No

270

Each

60.0000

1

1



Aft Cap



10/1/10

Location

Loc Qty

Loc Code

FP-4

51

57332

51

fp5

4

61752

4

FP6

5

52663

5

x1

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Page 7

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 8

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Work Order ID: 62279



Parent Item: D206-642-541



Parent Item Name: Replacement Skidtube

Start Date: 9/24/10

Required Date: 10/08/10

Start Qty: 1.00

Required Qty: 1.00

D3413-1

Manufactured

No

270

Each

36.0000

1

1



22 10/14/10

Ring

Location

Loc Qty

Loc Code

ST473

36

51586

1

53446

15

61322

20

X1

September 24, 2010 1:56:49 PM

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Page 8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN CP	DRAWN BY PH	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3274	REV. D SHEET 1 OF 4
DATE 06.12.19		TITLE SKIDTUBE ASSEMBLY SCALE NTS	
A	04.03.15	NEW ISSUE	
B	04.08.09	MOVE SADDLE HOLE: 42.14 WAS 42.76	
C	05.03.16	ADD -043; NEW INSERTS	
D	06.12.19	NEW INSERTS, SS WEARSHOE + GASKET	

RELEASED

07.02.12 **[Signature]**

DEO ATTACHED

Qty -041	Qty -043	Part Number	Description
X		D3274-041	SKIDTUBE ASSEMBLY
	X	D3274-043	SKIDTUBE ASSEMBLY
1	1	D2600-1-240	EXTRUSION
1	1	D2646	AFT CAP
12	12	D2649	CROSS BOLT SPACER
12	37	D3275-1	CROSS BOLT SPACER
1	1	D3282-041	FLOAT WEB
1	1	D3285-1	CAP
1	1	D3413-1	RING
1	1	D3415-041	NUT PLATE
1	1	D3535-15	WEARSHOE
1	1	D3535-23	WEARSHOE
1	1	D3535-35	WEARSHOE
1	1	D3535-39	WEARSHOE
1	1	D3536-15	GASKET
1	1	D3536-23	GASKET
1	1	D3536-35	GASKET
1	1	D3536-39	GASKET
9	9	D3537-1	WEARPAD
1	1	D3537-3	WEARPAD
78	78	ALS7-1032-130	INSERT (or AKS4-1032-130, ALS4-1032-130, AELS-1032-130)
80	80	AN3C4A	BOLT
1	1	AN4C5A	BOLT
1	1	AN960C416	WASHER
80	80	AN960C10L	WASHER
2	2	CCR264SS3-3	RIVET
2	2	CR3212-4-03	RIVET
2	2	NAS1515H3L	WASHER

GENERAL NOTES:

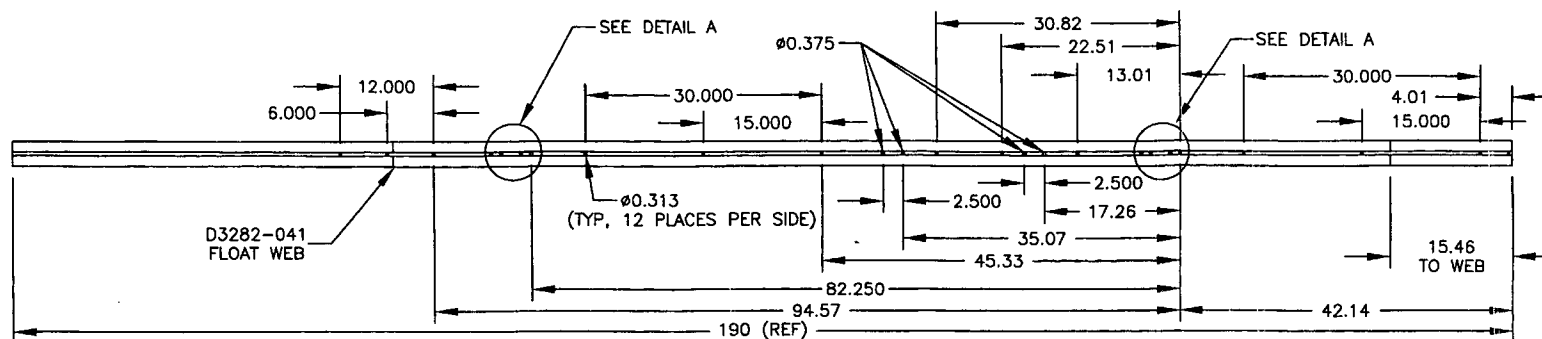
1. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
2. DAMAGE TOLERANCE ON FWD BEND:
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 7 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
3. ALL HOLES DRILLED ON CENTERLINES.
4. BOND D3282-041 FLOAT WEB INTO D3274-1/-3 OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241/291 ADHESIVE PER DART QSI 015. ENSURE HOLES LINE-UP.
5. WELDING TO BE DONE PER DART QSI 004.
6. FINISH: - ACID ETCH, ALODINE ASSEMBLY PER DART QSI 005 4.1
- POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
7. DRILL Ø0.297 HOLES FOR ALS7-1032-130 INSERTS USING DT3274-1T2 BEFORE FINISH. INSTALL ALS7-1032-130 INSERTS AFTER FINISH. SEAL WEARSHOE BOLTS WITH SIKAFLEX -241/-291.
8. SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.

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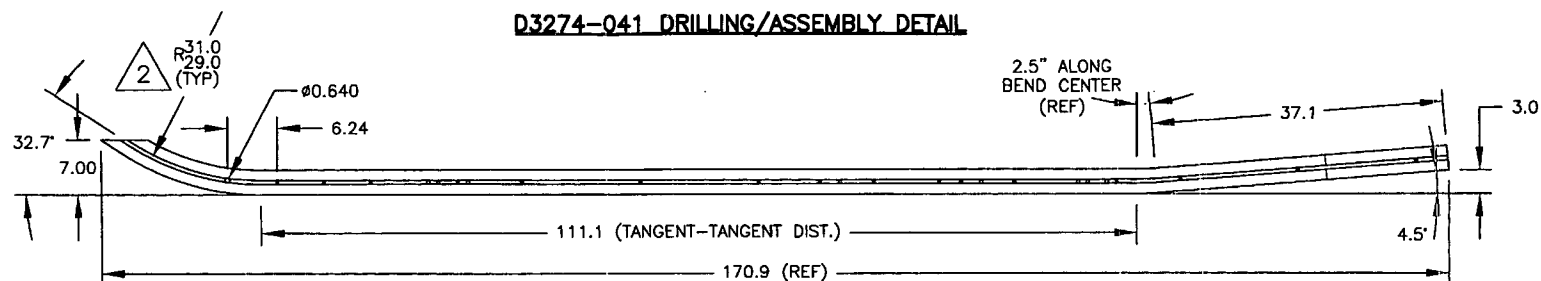
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CX1019124

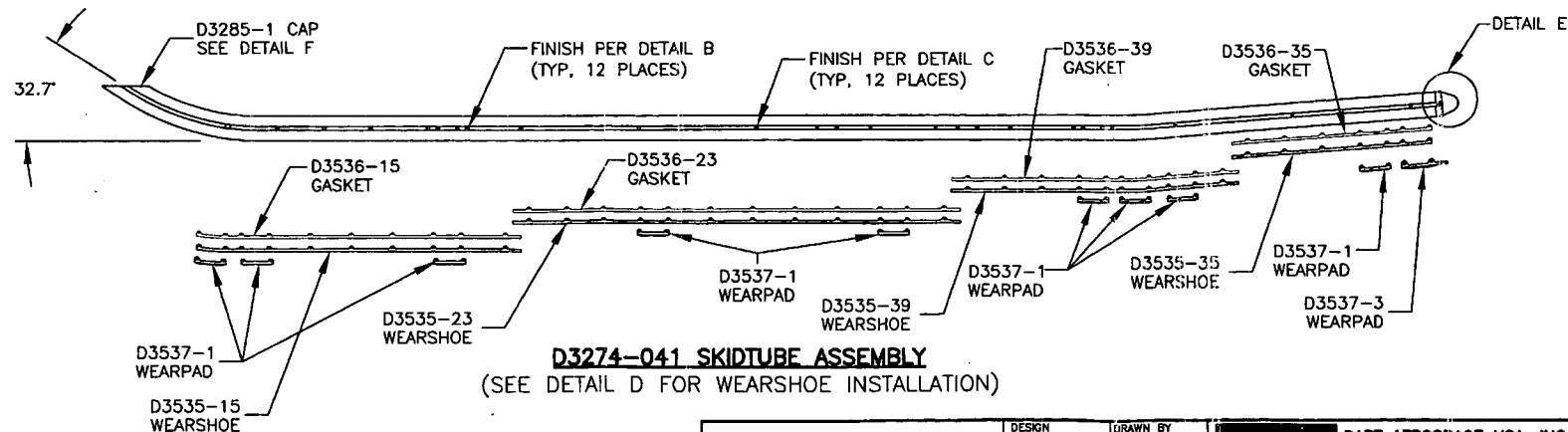
DEO ATTACHED



D3274-041 DRILLING/ASSEMBLY DETAIL



D3274-041 BEND/DRILLING DETAIL



D3274-041 SKIDTUBE ASSEMBLY
(SEE DETAIL D FOR WEARSHOE INSTALLATION)

RELEASED

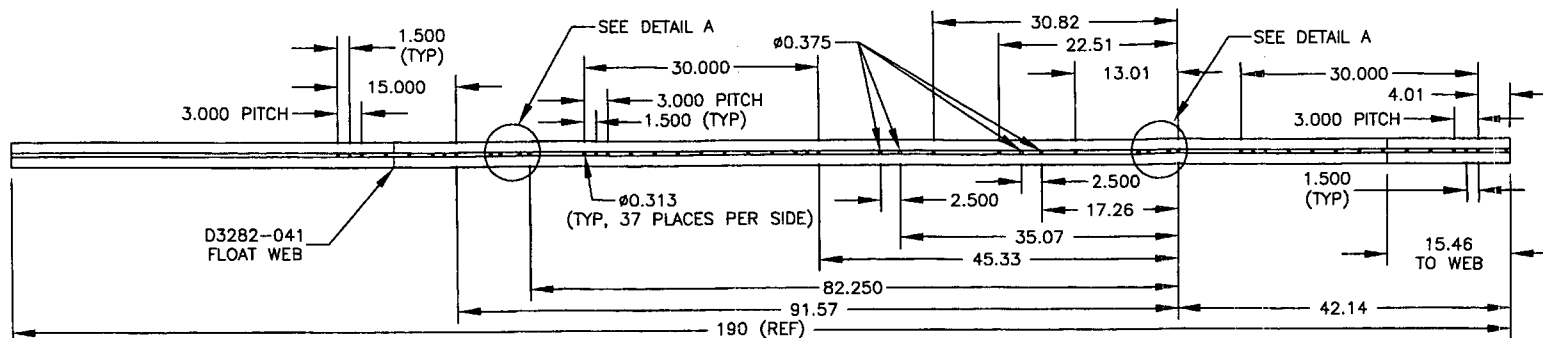
07.02.12

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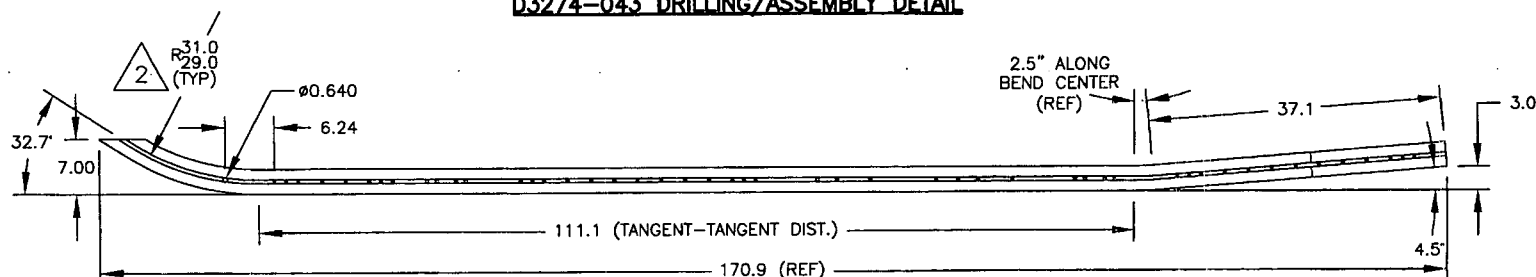
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DESIGN	CP	DRAWN BY	PH	DART DART AEROSPACE USA, INC. PORT HADLOCK, WA
CHECKED	#	APPROVED	#	DRAWING NO. D3274
DATE	06.12.19	TITLE	SKIDTUBE ASSEMBLY	REV. D SHEET 2 OF 4 SCALE 1:15

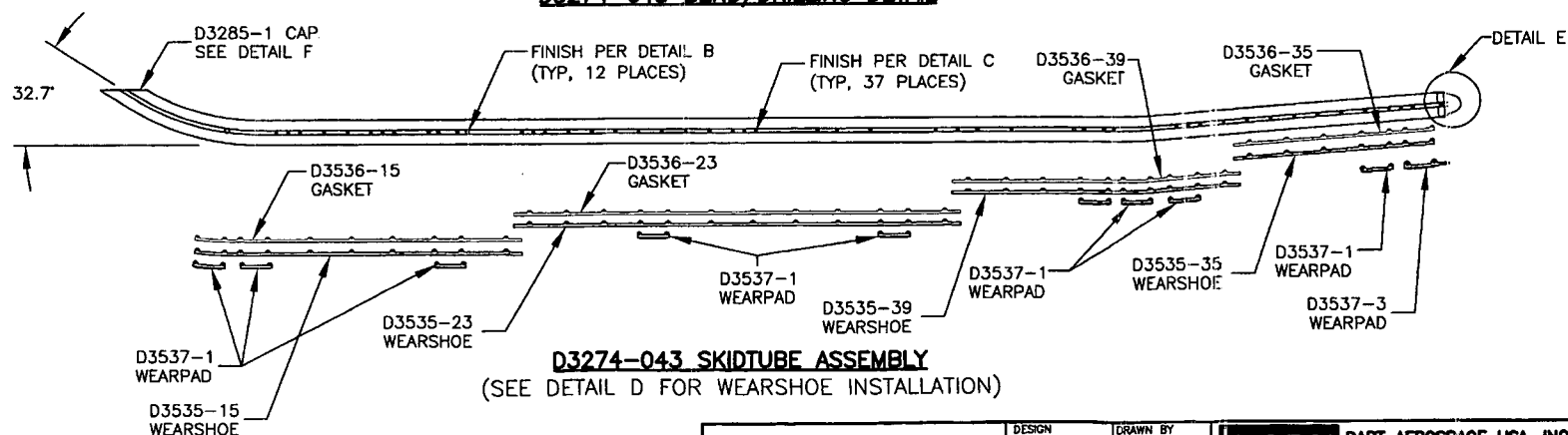
DEO ATTACHED



D3274-043 DRILLING/ASSEMBLY DETAIL



D3274-043 BEND/DRILLING DETAIL



D3274-043 SKIDTUBE ASSEMBLY
(SEE DETAIL D FOR WEARSHOE INSTALLATION)

RELEASED

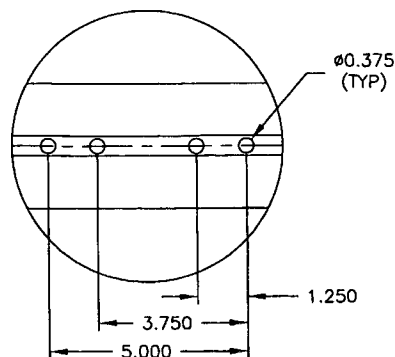
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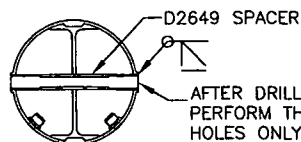
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CHECKED	H	APPROVED	H	DRAWING NO. D3274
DATE	06.12.19	TITLE	SKIDTUBE ASSEMBLY	REV. D SHEET 3 OF 4 SCALE 1:15

DETAIL A: DRILL DETAIL

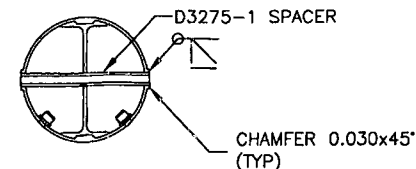


DETAIL B FOR Ø0.375 HOLES ONLY

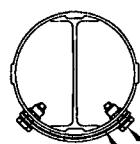


- AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR Ø0.375
HOLES ONLY:
1. CHAMFER HOLE 0.030x45°
 2. INSERT D2649 SPACER
 3. WELD INTO PLACE AND GRIND FLUSH
 4. C'BORE TO Ø0.313x0.75 DEEP

DETAIL C FOR Ø0.313 HOLES ONLY



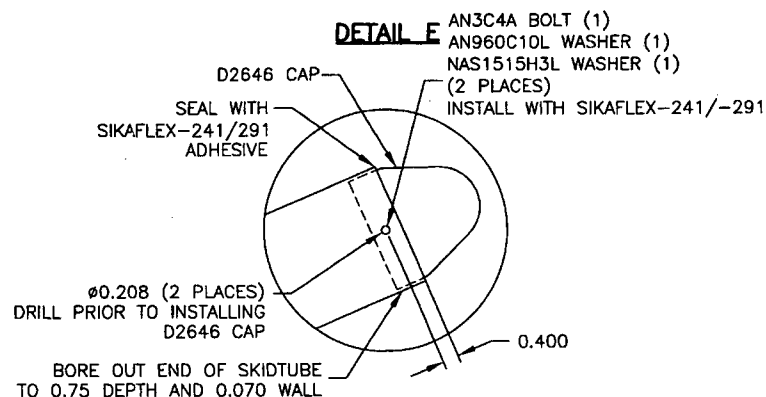
DETAIL D



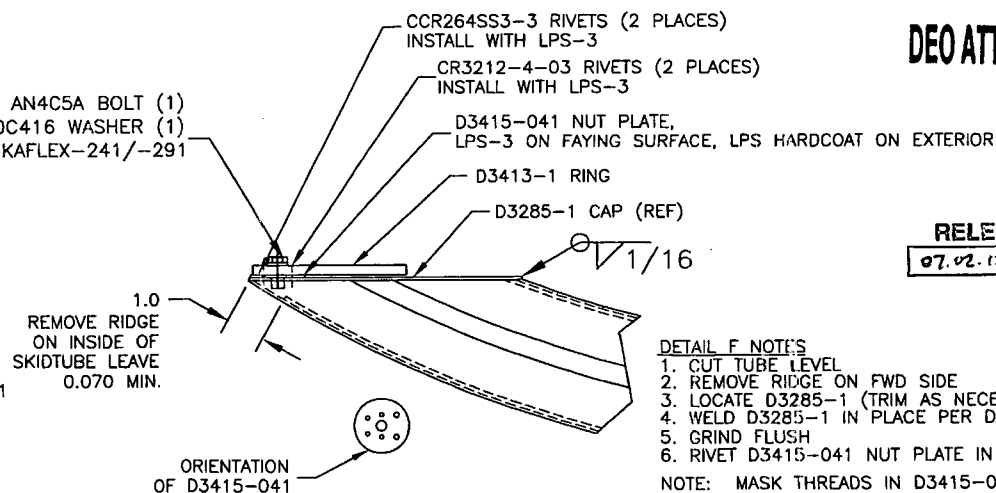
- AS7-1032-130 INSERT (1)
AN3C4A BOLT (1)
AN960C10L WASHER (1)
(78 PLACES)

GASKET/WEARSHOE/WEARPAD (REF)

DETAIL E



DETAIL F: END FINISHING DETAIL



DEO ATTACHED

RELEASED
07.02.12

- DETAIL F NOTES**
1. CUT TUBE LEVEL
 2. REMOVE RIDGE ON FWD SIDE
 3. LOCATE D3285-1 (TRIM AS NECESSARY)
 4. WELD D3285-1 IN PLACE PER DART QSI 004
 5. GRIND FLUSH
 6. RIVET D3415-041 NUT PLATE IN PLACE
- NOTE: MASK THREADS IN D3415-041
PRIOR TO FINISH

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		DATE	06.12.19			TITLE	SKIDTUBE ASSEMBLY
							REV. D SHEET 4 OF 4 SCALE 1:3

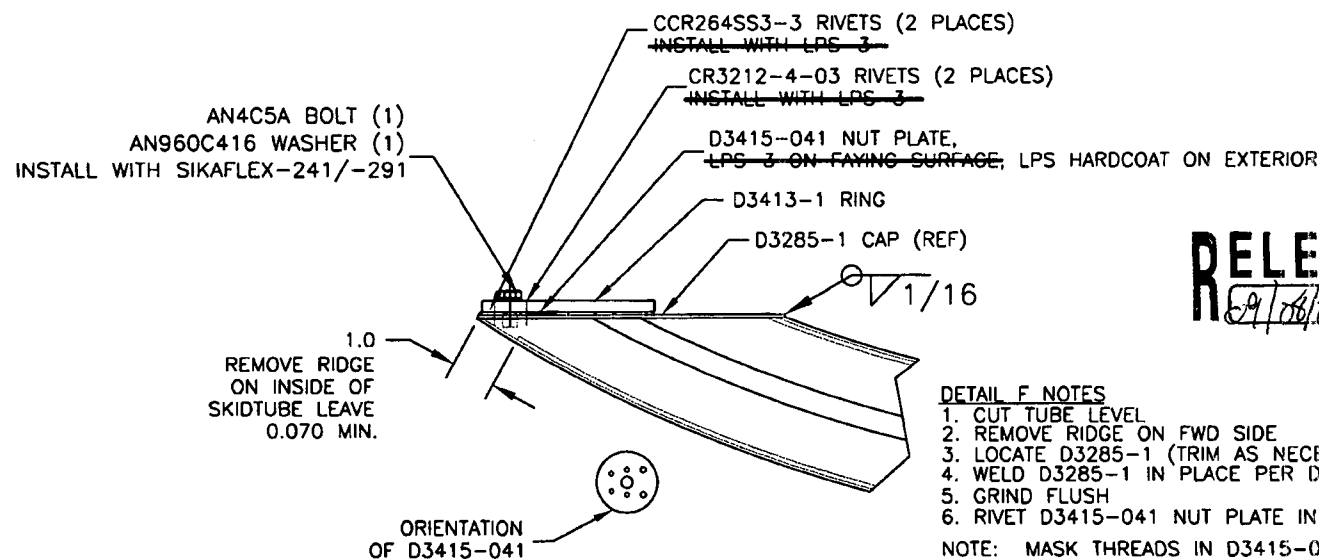
DRAWING NO. D3274	TITLE SKIDTUBE ASSEMBLY	REV. D	DART AEROSPACE USA, INC ENGINEERING ORDER	D.E.O. NO. D3274-D-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN <i>UP</i>	CHECKED <i>[Signature]</i>	MFG. APPR. <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DE APPR. <i>[Signature]</i>		
DATE 09.06.17	DATE 09.06.23	DATE 09/06/23	DATE 09/06/23	DATE 09.06.23		

LPS-3 IS NO LONGER USED DURING ASSEMBLY OF SKIDTUBE.

AMEND NOTE 8: "~~SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES 'LPS 3' AFTER FINISH AND INSTALLATION OF INSERTS.~~
COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES 'LPS PROCYON' AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF
POWDER COATING WITH MEK DEGREASER."

AMEND DETAIL F AS SHOWN:

DETAIL F: END FINISHING DETAIL



DETAIL F NOTES

1. CUT TUBE LEVEL
2. REMOVE RIDGE ON FWD SIDE
3. LOCATE D3285-1 (TRIM AS NECESSARY)
4. WELD D3285-1 IN PLACE PER DART QSI 004
5. GRIND FLUSH
6. RIVET D3415-041 NUT PLATE IN PLACE

NOTE: MASK THREADS IN D3415-041
PRIOR TO FINISH

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NO. 241

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barclay Elliott
Job number: 622500
Part number: D206-442-541
Description: 206 skid
Welding Process: Tig[☒] Mig[]
Base material: Aluminum
Current: AC[] DC[]

TEST REQUIREMENTS AND RESULTS

Visual: pass[☒] fail[]
Penetration: pass[☒] fail[]

UNACCEPTABLE

Cracks: pass[☒] fail[]
Undercut: pass[☒] fail[]
Pin holes: pass[☒] fail[]
Overlap (cold lap): pass[☒] fail[]
Porosity (surface): pass[☒] fail[]
Coloration: pass[☒] fail[]

Qualifier D.D. Date of Test Coupon 10-09-30
Welder Barclay Elliott Date of Test Coupon 10-09-30

The above named individual is qualified in accordance with AWS D17.1.2001 to weld.